

Date: Friday, 18/07/2008 10:50:31 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT		
Job Number	: 40617					
Estimate Number	: 10204					
P.O. Number	:			Part Number	: D21997	
This Issue	: 18/07/2008	S.O. No. :		Drawing Number	: D2199 REV. E1	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	:			Drawing Revision	: E1	
Written By	:			Material	:	
Checked & Approved By	: <u>JL 08.7.18</u>			Due Date	: 15/08/2008	
Comment	: Est:A 02.06.10 New Issue NG/RF			Qty:	5	
Um: Each						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
			5.00 <i>SB 08-107/2</i> (5)
		Comment: Qty.: 1.3125 f(s)/Unit Total : 6.5625 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)	Batch No: <i>M107518 (3) M108493 (2)</i>
2.0	BRAKE NC	NC BRAKE	
			<i>SB 08/107/2</i> (5)
		Comment: BRAKE NC Punch per Dwg. D2199 and Spec Control Dwg D2638	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			<i>SB 08/107/2</i> (5)
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	<i>EP 08/08/01 (5)</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP	
			<i>SB 08/08/01 (5)</i>
		Comment: INSPECT WORK TO CURRENT STEP	
5.0	POWDER COATING	POWDER COATING	
			<i>SB 08/08/01 (5)</i>
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	
	START TIME:	<i>9:15</i>	
	OVEN TEMPERATURE:	<i>400</i>	
	FINISH TIME:	<i>9:45</i>	<i>SB 08/08/05</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2199-7 PAR #: N/A Fault Category: Prod/finishing NCR: Yes No DQA: D Date: 08/06/04
D212-601-042 QA: N/C Closed: D Date: 09/09/08

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/08/05	D S.O	During QC3 Powder coat inspection it was found on 2 parts that there was some die/marking that came through the powder coat. R.C. Parts were not cleaned enough.	<u>D</u> <u>QAF/07</u>	Scuff with 380 grit sand paper till raw mat is showing. clean with acetin Re Powder coat as per QSTC05	<u>FD</u> <u>08/08/05</u> <u>M-F</u> <u>08/08/05</u> <u>M-F</u> <u>08/08/05</u>	<u>S</u>	<u>D</u> <u>08/08/05</u>	<u>6</u> <u>08/05</u>

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(S)

Comment: INSPECT POWDER COAT

8/1 88/08/05

7.0 PACKAGING 1

PACKAGING RESOURCE #1



(Sx)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 272

8/1 88/08/05

(S)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(G)

Comment: FINAL INSPECTION/W/O RELEASE

8/1 08/08/08

Job Completion



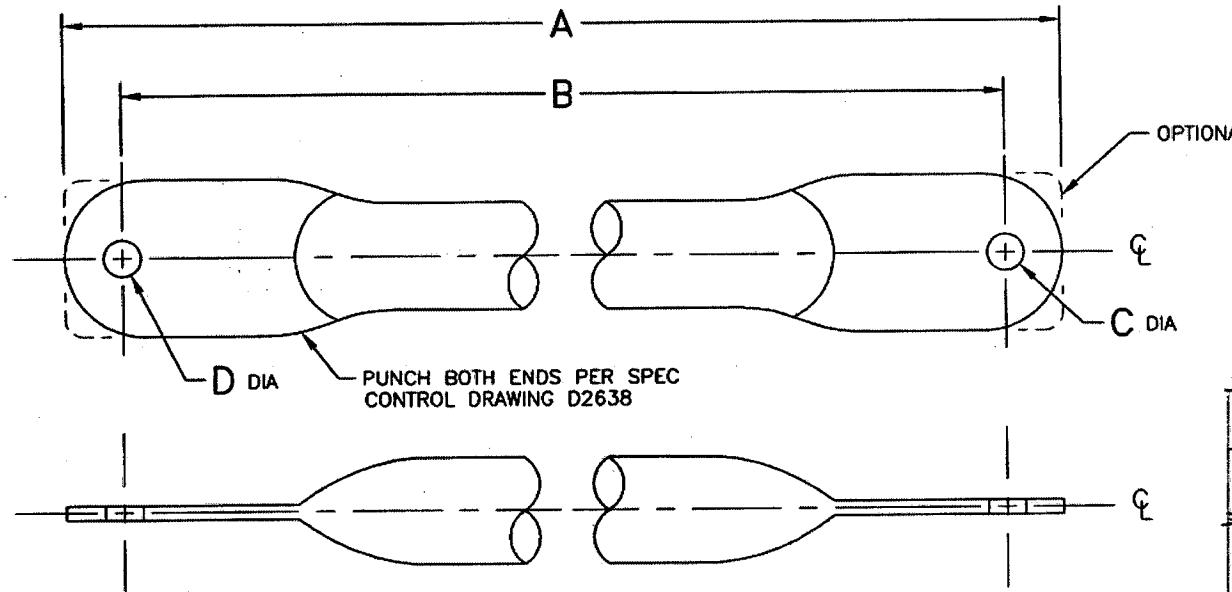
U 88/08/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

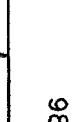
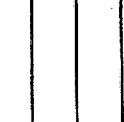
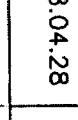
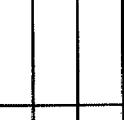


	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

B
B
B
C
C
D
E
E

NOTES:
1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\varnothing 0.750 \times 0.049$ WALL
3. FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3/EA



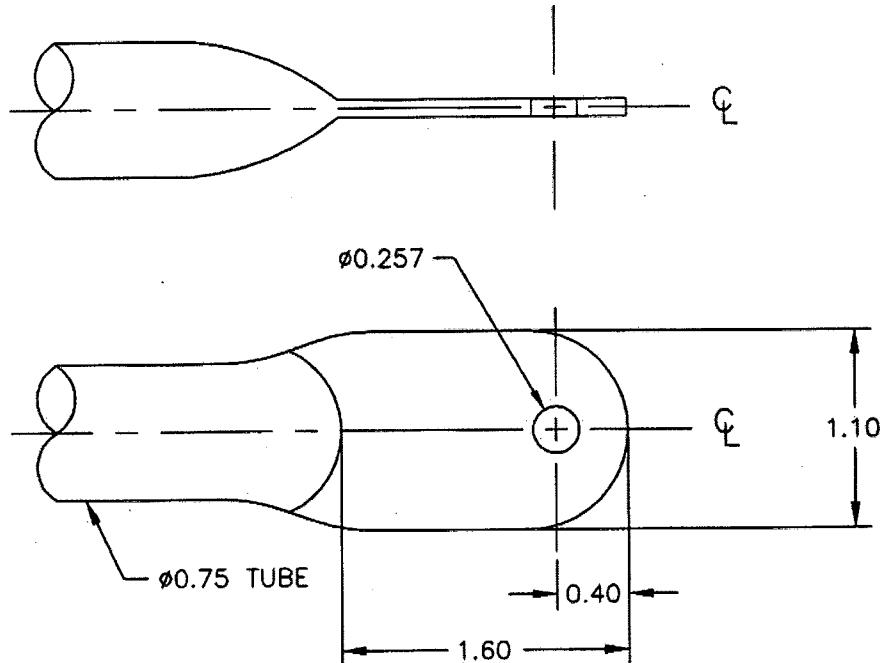
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DESIGN		DRAWN BY	
CHECKED		APPROVED	
DATE	98.04.28	DRAWING NO.	D2199
		TITLE	SHEET 1 OF 1
		STRUT DETAILS	SCALE NTS
A	1993	NEW ISSUE	
B		ADDED -11, -13, AND -15	
C		ADDED -17 AND -19	
D		ADDED -21	
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
E1	02.03.22	ADD FINISH	

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MM	APPROVED J	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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